

Work Order ID 138665-*split*

138665

Page 1

November 06, 2015 3:06:40 PM

Item ID: D350-615-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GHW Modification, Fits LH or RH

Start Date: 11/6/2015 Start Qty: *3* 5.00

5

Cust Item ID:

Required Date: 11/12/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: *SH* Date: *20151106*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-615-041	B
--------------	---

100	Document Control	0.00
-----	------------------	------

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHG003

3x

DAS
28
9-89

DEC 15 2015

110		0.00
-----	--	------

110

Small Fab

Small Fab

Memo

0.01

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***

3

FF

DEC 15 2015

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

120

QC

Quality Control

Memo

0.00

DAS
30
9-89

3

DEC 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 138665

138665

Page 2

November 06, 2015 3:06:40 PM

Item ID: D350-615-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GHW Modification, Fits LH or RH

Start Date: 11/6/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/12/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Memo

0.00

Quality Control

3x

DAS
28
9-89

DEC 15 2015

140

0.00

140

Packaging

Memo

0.00

Packaging

Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041
Location :FG023

3

DAS
28
9-89

DEC 15 2015

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.01

Quality Control

MLC

DEC 15 2015

MLC

DEC 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

November 06, 2015 3:06:45 PM

Page 1

Work Order ID: 138665

138665

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 11/6/2015

Required Date: 11/12/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2282-041		Manufactured	No			110	Each	3.0000	1	DAS 30 9-89			
D2282-041									**				
T Assembly													DEC 14 2015

Location

Loc Qty

Loc Code

GA

3

B 134512 ③

137286

3

D2282-043		Manufactured	No			110	Each	0.0000	1	DAS 5 30 9-89			
D2282-043									**				
Saddle Assembly													DEC 14 2015

5/16-18-015C		Purchased	No			110	Each	173.0000	3	15			
5/16-18-015C									**				
SS Bolt 5/16-181.5"K													DAS 6 9-89

Location

Loc Qty

Loc Code

st572

173

m133171

173

D3015-3		Manufactured	No			110	Each	110.0000	3	15			
D3015-3									**				
Locknut													DAS 6 9-89

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

92

136803

92

NOV 11 2015

Picklist Print

November 06, 2015 3:06:45 PM

Page 2

Work Order ID: 138665

138665

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 11/6/2015

Required Date: 11/12/2015

Start Qty: 5.00

Required Qty: 5.00

5/16WC

Purchased

No

110

Each

176.0000

12

60

5/16WC

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

st572

176

m133503

176

60

7/16-14-050C

Purchased

No

110

Each

10.0000

1

5

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

DAS
6
9-89

Location

Loc Qty

Loc Code

st572

10

120146

2

m133197

8

5

D3015-5

Manufactured

No

110

Each

22.0000

1

5

D3015-5

SS Nylock Nut 7/16

DAS
6
9-89

Location

Loc Qty

Loc Code

ST015

22

99599

22

5

7/16WC

Purchased

No

110

Each

66.0000

2

10

7/16WC

Washer, SS Flat 7/16

DAS
6
9-89

Location

Loc Qty

Loc Code

st572

66

120508

66

10

NOV 11 2015